



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D212-664-101
Job Sheet 203702



Part No: D212-664-101

Job Qty: 1 pcs

Part Name: Fwd Crosstube - High

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/25/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/13/19

Description:

Note: D212-664-141 REV E/ IIN-D212-664 REV.J IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove Comments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-549 EC verf by:DD IPP REV:I 14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier	Lead Time	Sign-off
120	Crosstubes - Bend - 1	1 pcs	12/13/19		0.50	1.00	Crosstubes - Bend			
130	QC 15	1 pcs	12/13/19		0.00	0.00	QC 15 - 12			
							QC 15 - 3			
							QC 15 - 47			
							QC 15 - 49			
							QC 15 - 58			
							QC 15 - 9			
							QC 15 - 68			
140	Crosstubes - 2 - B4B	1 pcs	12/13/19		0.00	1.00	Crosstubes - 1 - B4B			
							Crosstubes - 2 - B4B			
							Crosstubes - 3 - B4B			
							Crosstubes - 4 - B4B			
160	QC 7	1 pcs	12/13/19		0.00	0.00	QC 7 - 10			
							QC 7 - 13			
							QC 7 - 14			
							QC 7 - 15			
							QC 7 - 17			
							QC 7 - 18			
							QC 7 - 19			
							QC 7 - 2			
							QC 7 - 28			
							QC 7 - 3			
							QC 7 - 30			
							QC 7 - 34			
							QC 7 - 36			
							QC 7 - 37			
							QC 7 - 41			
							QC 7 - 47			
							QC 7 - 48			



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CANADA
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Container No: S234907



Part: D212-664-101

Job No: 203702

Serial No/Batch: S234907

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298N

					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	DAS NOV 28 2019 68
					QC 7 - 50	9-81
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
165	QC 5	1 pcs	12/13/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	NOV 28 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170	Outsource - 2 - NDT per QSI038	1 pcs	12/13/19		SKY002-VC	2019-11-29
180	Packaging 2-1 - Receive - B4B	1 pcs	12/13/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	NOV 29 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	

				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 5	1 pcs	12/13/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
QC 5 - 81					
200 Spray Paint - 2 - B4B	1 pcs	12/13/19	0.00 0.25	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
210 QC 14	1 pcs	12/13/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				Plex 11/25/19 3:08 PM	Dart.lajeunesse.marie

DAS
40
9-89

DEC 02 2019

DAS
41 DEC 02 2019
9-89

						QC 14 - 34	
						QC 14 - 41	
						QC 14 - 51	
						QC 14 - 58	
						QC 14 - 59	
						QC 14 - 9	
						QC 14 - 68	DAS DEC 06 2019 68
						QC 14 - 40	9-89
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
						QC 14 - 61	
						QC 14 - 81	
220	Crosstubes - 4 - B4B	1 pcs	12/13/19	0.00	1.69	Crosstubes - 1 - B4B	
						Crosstubes - 2 - B4B	2019-12-4
						Crosstubes - 3 - B4B	
						Crosstubes - 4 - B4B	
230	QC 5	1 pcs	12/13/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS DEC 09 2019 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
240	Packaging 1-1 - Pick Kit - B4B	1 pcs	12/13/19	0.00	0.00	Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 -	

				B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
250	QC 4	1 pcs	12/13/19	0.00 0.00	QC 4 - 28
					QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
					QC 4 - 78
260	Packaging 3-1 - Stock - B4B	1 pcs	12/13/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 -

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				B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
265 DC - 1 - B4B	1 pcs	12/13/19	0.00 0.00	DC - 1 - B4B	JAN 09 2020
				DC - 2 - B4B	
270 QC 21 - FG	1 pcs	12/13/19	0.00 0.00	QC 21 - FG - 21	JAN 09 2020
				QC 21 - FG - 70	
				QC 21 - FG - 53	
Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101 Descriptions: 130 - (QC15- Crosstube Dimensional Check) 140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141" 5- Adodine cross tube immediately after grinding. 160 - (QC7-Inspect Chemical Conversion Coat) 165 - QC5- Inspect part completeness to step on W/O) 170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as					

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per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - (Receive & Inspect for Damage & Mat'l Certs) Ensure copy of NDT results attached to work order.

190 - (QC5- Inspect part completeness to step on W/O) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D212-664-141

200 - (Spray Paint / NDT Room) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 5189223 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 clear 5184743 Paint 5231052

210 - (QC14- Inspect Spray Paint) Then, Wrap in plastic bag to protect from scratches

220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 5229895 EXP: 20-3 PROSEAL CURE TIME 72 HOURS: Start: 20-12-4 Finish: 20-12-7 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.***

230 - (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

240 - (Pick Kit)

250 - QC4- 100% Inspect kits for completeness) ***VERIFY BY _____ BATCH # TO MATCH W/O

260 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D212-664-101 Location : FG094

265 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG007

270 - (QC21- Final Inspection - Work Order Release)

013363

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-101TRN	Crosstube Turning Detail	1 pcs (1 ea)	120-Crosstubes - Bend - 1	<u>5212839</u>
D2893-1	Support	2 pcs (2 ea)	220-Crosstubes - 4 - B4B	<u>5226430</u>
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 pcs (4 ea)	220-Crosstubes - 4 - B4B	<u>5217151</u>
MS21920-25	Clamp	4 Ea (4 ea)	220-Crosstubes - 4 - B4B	<u>5203219</u>
AN6-35A	Bolt	4 Ea (4 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5089333</u>
AN6-36A	Bolt	4 Ea (4 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5225630</u>
D3428-1	Placard	1 pcs (1 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>514033</u>
MS21042L6	Nut	6 Ea (6 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5232552</u>
NAS1149D0663J	Washer	18 Ea (18 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5222693</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Crosstubes - Bend - 1	D212-664-101TRN	1	7	0
220-Crosstubes - 4 - B4B	D2893-1	2	17	0
	D3595-063-450	4	99	0
	MS21920-25	4	93	0
240-Packaging 1-1 - Pick Kit - B4B	AN6-35A	4	39	0
	AN6-36A	4	57	0
	D3428-1	1	17	0
	MS21042L6	6	153	0
	NAS1149D0663J	18	467	0

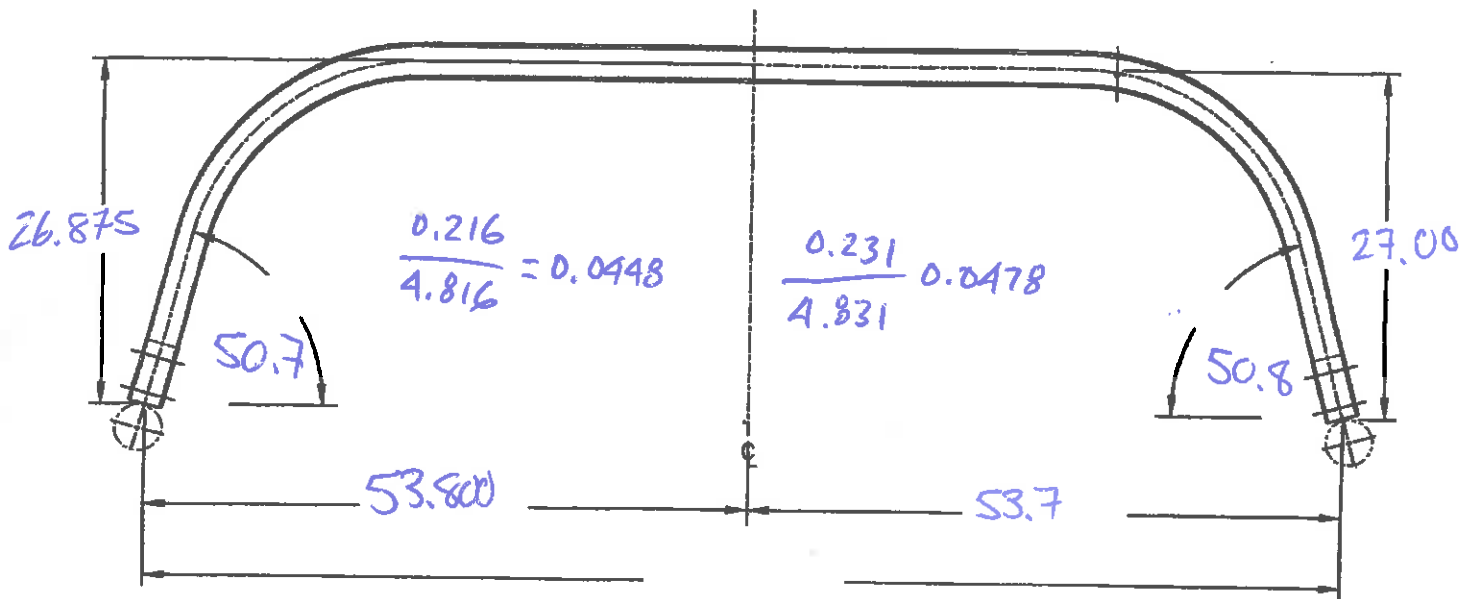
Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	203702
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



2.300
2.516

	Side A	Side B
Bending Passes	5	5
Crushing	4.5%	4.8%
Comments		

2.300
2.531

QC15 Inspection	DAS 68
Date	NOV 28 2019

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ	

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-864-141	CROSSTUBE ASSEMBLY (205212412 HIGH FWD)
2		X		D212-864-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-864-141F	CROSSTUBE ASSEMBLY (205212412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2	2	2	D2893-1	SUPPORT
6	4	4	4	D3995-063-450	RUBBER CUSHION
7	2	2	2	D6017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	AR	AR	AR	PROSEAL 880 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C8-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
f) ANODIZE PER MIL-A-8825, TYPE II, CLASS 1.
g) ALDINE (DO NOT ETCH) PER QSI 005 4.1.2
h) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
i) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C8-2 / C6-3, HATCHED AREA)
j) PAINT OUTSIDE PER DART QSI 005 4.2
k) REMOVE MASKING AND APPLY MATTE CLEAR COAT

FINISH -141F:

NOTE: BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-864-XXX" AND BATCH NUMBER ON INSIDE OF CLIFF USING VIBRATING STYLUS
- 7) WEIGHT: D212-864-141/141B/141F = 33.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLEND OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- 10) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.

BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 9% (BASED ON O.D.) ON REMAINING TUBE.
- 12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- 13) TO INSTALL D2893-1 / D6017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 880 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 14) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3995-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 880 SEALANT HAS CURED FOR 72 HOURS.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 103702M5
19-11-25

RELEASED
2014-05-26

E	ADD -141F. D6017-1 WAS D2893-1 (-141B). PROSEAL WAS MAGNIBOND. NOTE 2: ADD INSPECTION WINDOWN, NOTE 11: ALLOW 7.2% CRUSH. NOTE 16: ADD 214 CURVE AND RETORQUE FOR PROSEAL. ADD SHEET 2 TO CLAMPS REVERSED TO PREVENT CHIPPING (BT-3, BT-3). BEND HEIGHT TOL. NOW 0.28 WAS 0.13 (CT-3). INCORP. DEO D-1/2-3	CP	14.04.01
D	REFORMA/REUSE GENERAL NOTEPART LIST: REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS: ADD -141B (214 HIGH FWD); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3 & B9-3); RELOCATED PLUG IN PER P&G 05-046 (214 AS); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.06.30
C	REMOVE -451 ABRASION STRIP; ADD MAGNIBOND 6295. CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D212-864-141
REV. E
SHEET 1 OF 6

TITLE XTUBE ASSY (205212412 HI FWD)
SCALE NTS

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RELEASED
2014-05-26

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation							
Disposition							
Completed By							
Lead hand / Supervisor							
QC / QA Coordinator							

Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
--	--	--	--	--	--



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045257



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045257

PO Date: 11/28/19

Due Date: 11/29/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201477	D212-664-101	D212-664-141/111	D212-664 E/J Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	11/29/19	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
	201478		X1	NOV 29 2019	Firmed	-	11/29/19	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
	201479		X1	NOV 29 2019	Firmed	-	11/29/19	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
	203702		X1	NOV 29 2019	Firmed	-	11/29/19	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
								Sub Total:	4	0	4	\$835.00
											Grand Total:	\$835.00

Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045257



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/29/19 11:27 AM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO42710	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB045257
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 4 FWD CROSSTUBES P/N# D212-664-101 , J/S# 201477 , 201478 , 201479 , 203702

DA
4
9-89

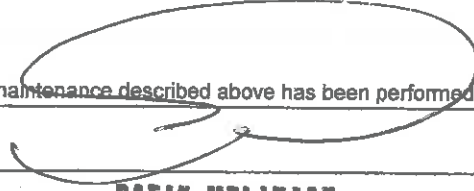
Action Taken:		Date:	Initial/Stamp:			
LPI C/O IAW ASTM E-1417M-16 ***NO CRACK FOUND*** PEN. ZL-67, MPO25403, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142		NOV 29 2019	 			
Miscellaneous AD Review Performed: ☐ No applicable AD's noted ☐ Refer to action taken for applicable AD's						
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

RECEIVED

NOV 29 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: NOV 29 2019
Name: RAFIK MELIKIAN		

SKYM002-1 REV 7 Apr/17

Change Record

PAGE 1 OF 1

Part Number: D212-664-101/-101MB

Description: CROSSTUBE INSTALLATION, HIGH FWD

[illegible]